

Work Order ID 147977

Wednesday, June 22, 2016 9:07:37 AM

147977

Page 1

Item ID: D3307-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Access Panel Assy LH

Start Date: 6/30/2016 Start Qty: 6.00

6

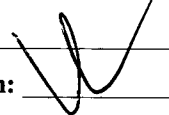
Cust Item ID:

Required Date: 7/8/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3307	Rev C								

PR 2016/06/30

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.18

FLOW CNC Waterjet

1-Cut D3307-1 as per Dwg D3307 Dwg Rev: CProg Rev: C

2-Deburr if necessary

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

7

PR 2016/06/30

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Page 2

Item ID: D3307-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assy LH
 Start Date: 6/30/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 7/8/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120						(7)			
QC	Memo	0.02							
Quality Control									JUL 04 2016
130	Form as per dwg NC BRAKE	0.00							
130						7	FF		JUL 05 2016
Brake NC	Memo	0.46							
Brake NC									
140	Small Fab	0.00							
140						7	FF		JUL 06 2016
Small Fab	Memo	0.17							
Small Fab	1- Bond D3307-3 gasket to D3307-1 panel as per dwg D3307								
	A/R 3M scotch-grip adhesive Batch: <u>H134871</u>								

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Item ID: D3307-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Access Panel Assy LH
 Start Date: 6/30/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 7/8/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
150						7			
QC	Memo	0.02							
Quality Control									JUL 06 2016
160	Identify as per dwg & Stock Location: Sto31	0.00							
160									
Packaging	Memo	0.01							
Packaging									7 JUL 07 2016 DAS 6 9-89
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							
Quality Control									HJ / RJA 16/07/12 DAS 21 9-89 JUL 11 2016

Picklist Print

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Page 1

Work Order ID: 147977

147977

Parent Item: D3307-041

D3307-041

Parent Item Name: Access Panel Assy LH

Start Date: 6/30/2016

Required Date: 7/8/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A08.08.05New issue EC verified by:DD IPP REV:B
12.11.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3307-3		Manufactured	No			140	Each	6.0000	1	6			
D3307-3													
Gasket													

Location Loc Qty Loc Code

GA * 148205 6
147797 6

M304S22GA		Purchased	No			100	sf	122.7750	0.26	1.56			
M304S22GA													
304/316 .032 Sheet													

Location Loc Qty Loc Code

MAT020 122.775
m126593 28.475
m131999 30.3
m134399 64

3
4
1.56

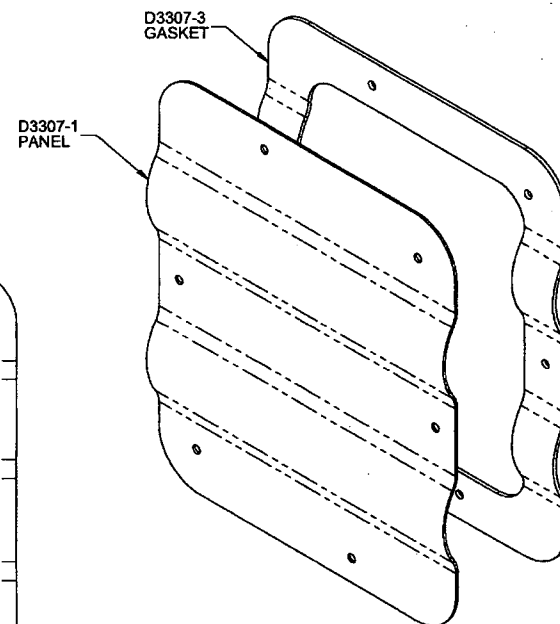
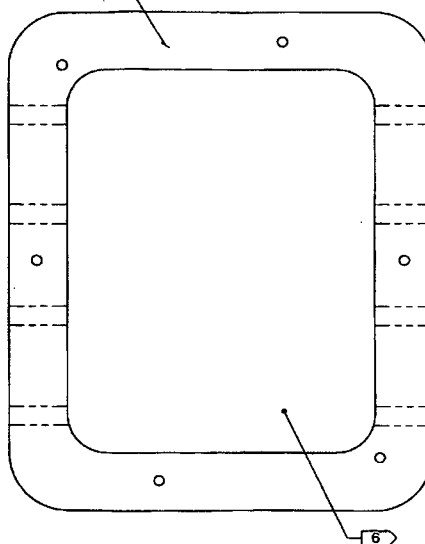
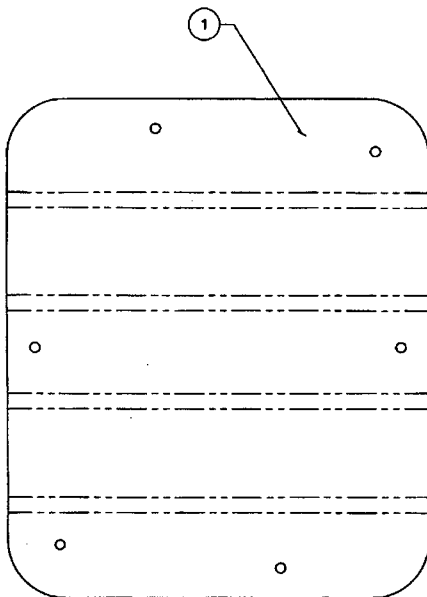
1.8

FF JUL 06 2016

PR 2016/06/30

ITEM	QTY	P/N	DESCRIPTION
	X	D3307-041	ACCESS PANEL ASSY
1	1	D3307-1	PANEL
2	1	D3307-3	GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 147937 MJS
1606-28



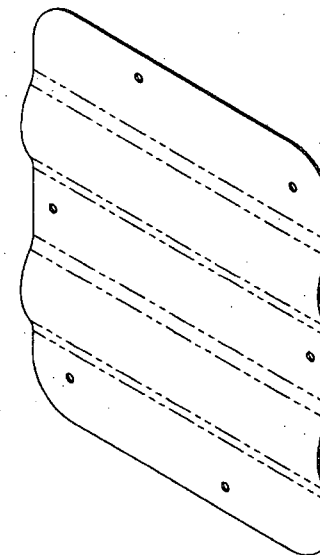
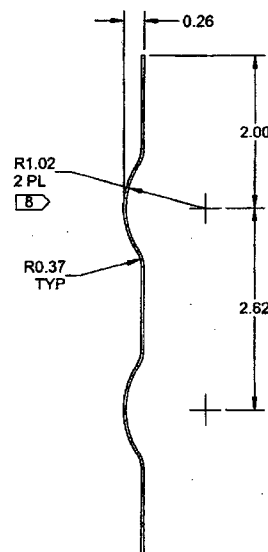
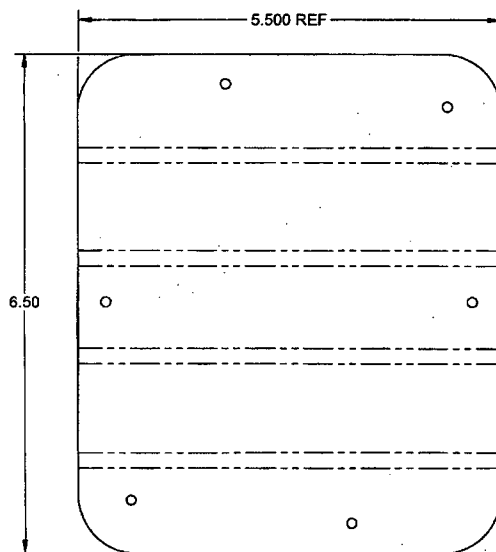
RELEASED
2012-11-06
WJ

D3307-041 ACCESS PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3307-041" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.39 lbs
- 8) INSTALL GASKET ON THIS SIDE USING 3M SCOTCH-GRIP ADHESIVE P/N 1300/1300L IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

C	CHANGED MATERIAL FOR D3307-3 REASON: PROCUREMENT, REF CAR12-69.	MB	12.10.17
B	- MOVE TWO DIAGONAL CORNER HOLES TO ELIMINATE INTERFERENCE AT INSTALLATION POINT. - CORRECTED FLAT PATTERN OVERALL LENGTH (C4-3) - REF: PAR 12-165	RP	12.04.11
A	NEW ISSUE	RF	04.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.10.17		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3307		REV. C	SHEET 1 OF 4
TITLE ACCESS PANEL ASSY		SCALE	NTS
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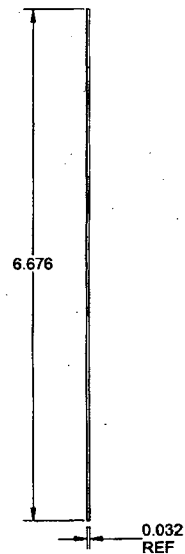
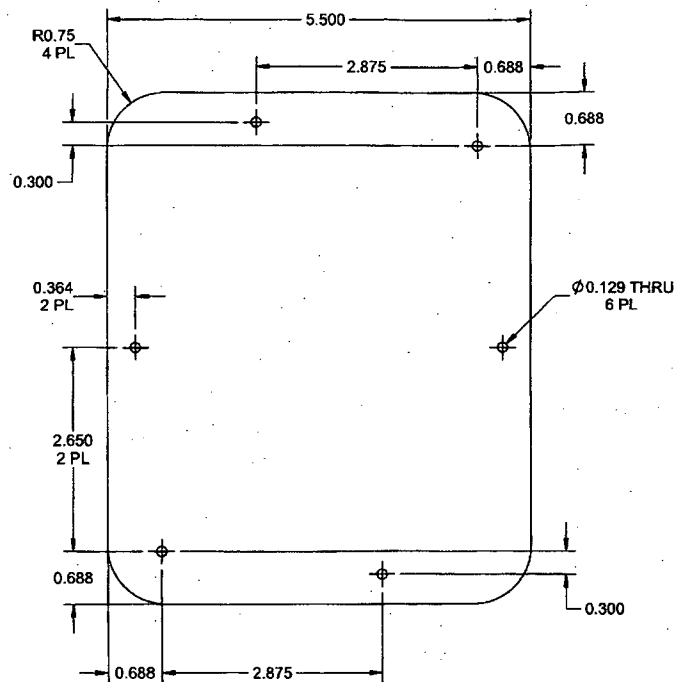
D3307-1 PANEL

RELEASED
R 2012-11-06
JAN

NOTES:

- 1) MATERIAL: MAKE FROM D3307-1F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) FORM USING DT8745

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3307	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	
DATE	12.10.17	NTS	
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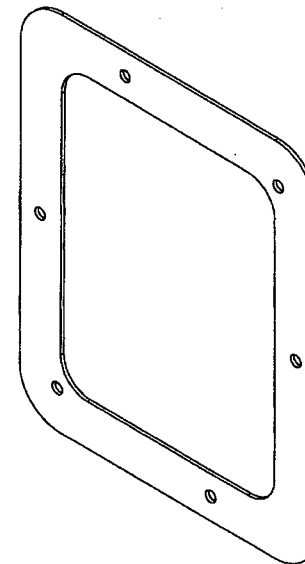
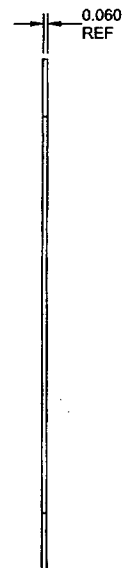
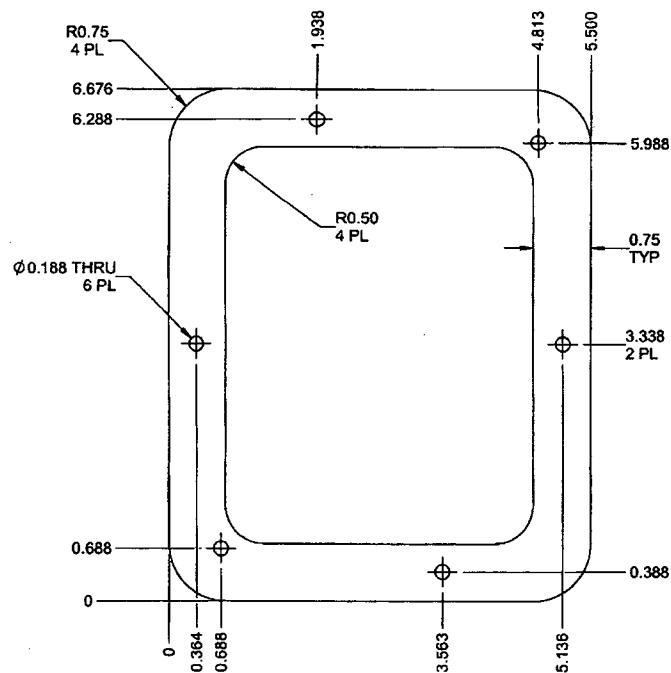
D3307-1F PANEL (FLAT PATTERN)

RELEASED
2012-11-06

NOTES:

- 1) MATERIAL: AISI 304/316 SS, ANNEALED, 2B FINISH, 0.032 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240
OR ASME SA240. (REF. M304S22GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

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MFG. APPR.		D3307	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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D3307-3 GASKET

RELEASED
2012-11-06

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: N/A
- 3) TOLERANCES: ALL DIMENSIONS FOR D3307-3 ARE +/- 0.02 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

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CHECKED		DRAWING NO.	REV. C
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APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
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